

Date: Thursday, 12/15/2005 3:56:27 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR ASSEMBLY	
Job Number	: 25261		Part Number	: D32133	
Estimate Number	: 10712		Drawing Number	: D3213 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	12/15/2005	S.O. No. : <i>12/15/2005</i>	Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 1/10/2006	
Previous Run	: N/A		Qty:	12	
Written By	: See comment below		Um:	Each	
Checked & Approved By	: See comment below				
Comment	: Est Rev:A New Issue 05-11-17 JLM				

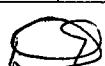
Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet 
Comment: Qty.: 0.4950 sf(s)/Unit Total : 4.9497 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Identify as D3213-3 Batch: <i>M19059</i> SA 05.12.21		
2.0	SHEAR	SHEAR 
Comment: SHEAR Cut blanks: 15.100" x 4.500" (+0.000/-0.010) SA 05.12.21 12 X0		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3213-1 as per Folio FA350 and Dwg D3213 Stack of 4 JL 06.01.09 12 PTO		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE JL 06.01.09 12		
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK En 06/01/09 12		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/13
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-01-09	3	hole distance to edge is .012 over .010 tolerance on the .300 measurement, because the blank was cut .020 to short. blank length is within the .030 tolerance (15.00)	 Initial 06-01-09	Acceptable.	 Sign 06-01-09	 06-01-09	 06-01-09	 06-01-09

NOTE: Date & initial all entries

Date:
User:

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Drawing Name: DOOR ASSEMBLY

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Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAJ 06/01/11 12

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAJ 06/01/11 12

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/01/11 12

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A - a code for w/o
28284

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAJ 06/01/13 (12)

SB 06/01/13 (12)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25261
Description: Door Panel	Part Number:	D3213-3
Inspection Dwg: D3213	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>J.L</u>	Audited by: <u>MS</u>	Prototype Approval: N/A
Date: <u>06.01.09</u>	Date: <u>06/01/09</u>	Date: N/A

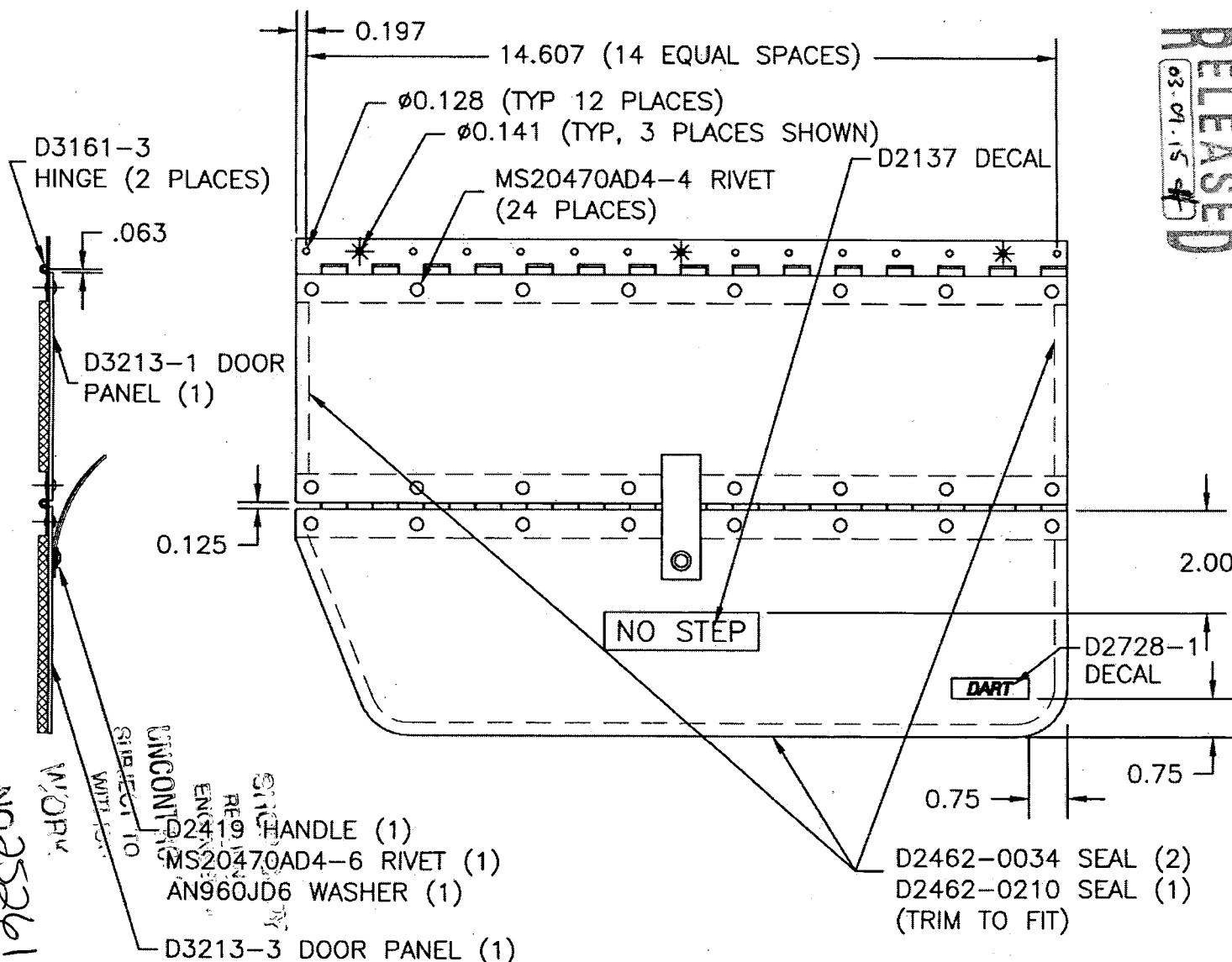
Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	04.06.15	Tolerance changed for 14.400 dimension	KJ/JLM	

DART

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DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3213
DATE		REV. A
03.09.03		1 OF 2
TITLE		SCALE
DOOR ASSEMBLY		1:3

RELEASED
03.09.03



D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3

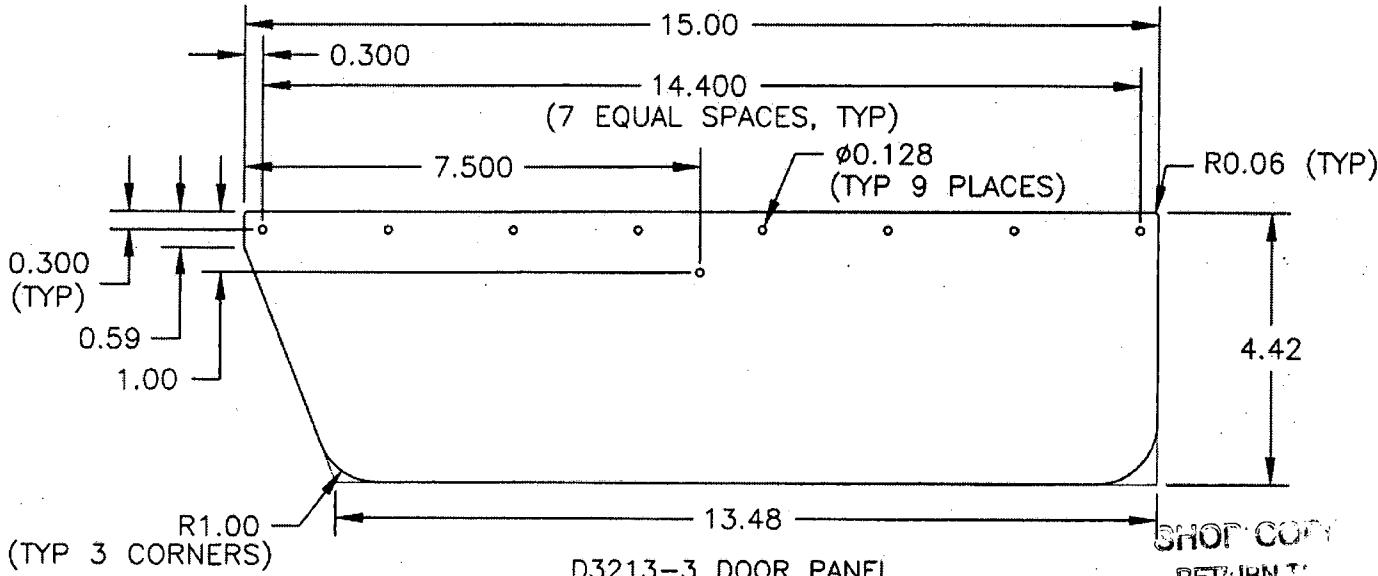
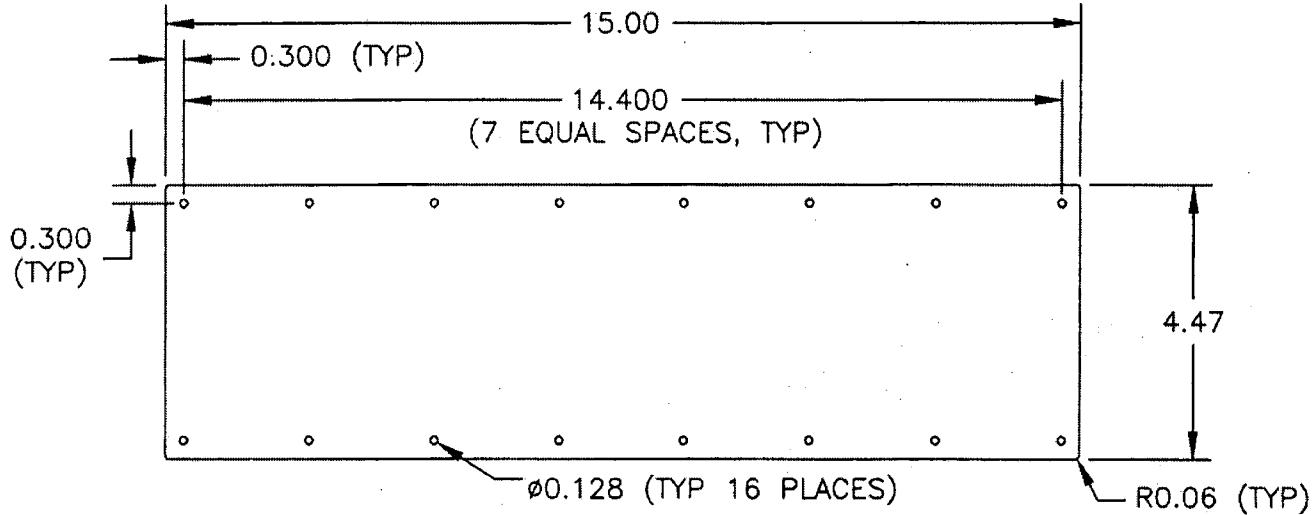
INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3213
DATE		REV. A 2 OF 2 SCALE 1:3

03.09.03 TITLE DOOR ASSEMBLY

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03/09/03
WITH 100

WORK

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